

Work Order ID 119491

Friday, May 16, 2014 12:51:04 PM

646.9811

119491

Page 1

Item ID: 646.9811

Revision ID:

Item Name: Upper Deflector

Start Date: 5/15/14

Required Date: 5/15/14

Reference:

Start Qty: 400

Req'd Qty: 400

4

4

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: 14-05-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.9800

A

100

0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 32.700"

*** ONE BLANK MAKES TWO PARTS***

0.00

DAS
02
1-89

14 - 06 - 04 (x6)

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB131

DWG REV: 4

FOLIO REV: 4A

2- deburr and break all sharp edges

0.00

14/06/08

6 0

DAS
14
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____



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Picklist Print

Friday, May 16, 2014 12:51:08 PM

Page 1

Work Order ID: 119491

119491

Parent Item: 646.9811

646.9811

Parent Item Name: Upper Deflector

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12/09/10 JFS VERIFY BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T6B5.000X0.375

Purchased

No

100

f

52.4600

1.36

6
DAS
02
9-89

M7075T6B5 000X0.375

7075-T6 BAR 5.000" X 0.375"

**

14-06-04

Location

Loc Qty

Loc Code

MAT049

52.46

m126615

8

m127614

1.5

m128502

42.96

x8.19

DQA: _____ Date: _____



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FAULT CATEGORY

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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03828

SHEET 1 OF 8

DWG NO. 646.9800

REV: NC

PREPARED BY: B. PETERS

DATE: 03/19/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: DEFLECTOR

APPROVED BY:

ENGR.

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED CORNER RADIUS, TOLERANCES, AND ADDED INSPECTION DIMENSIONS.

ECR:

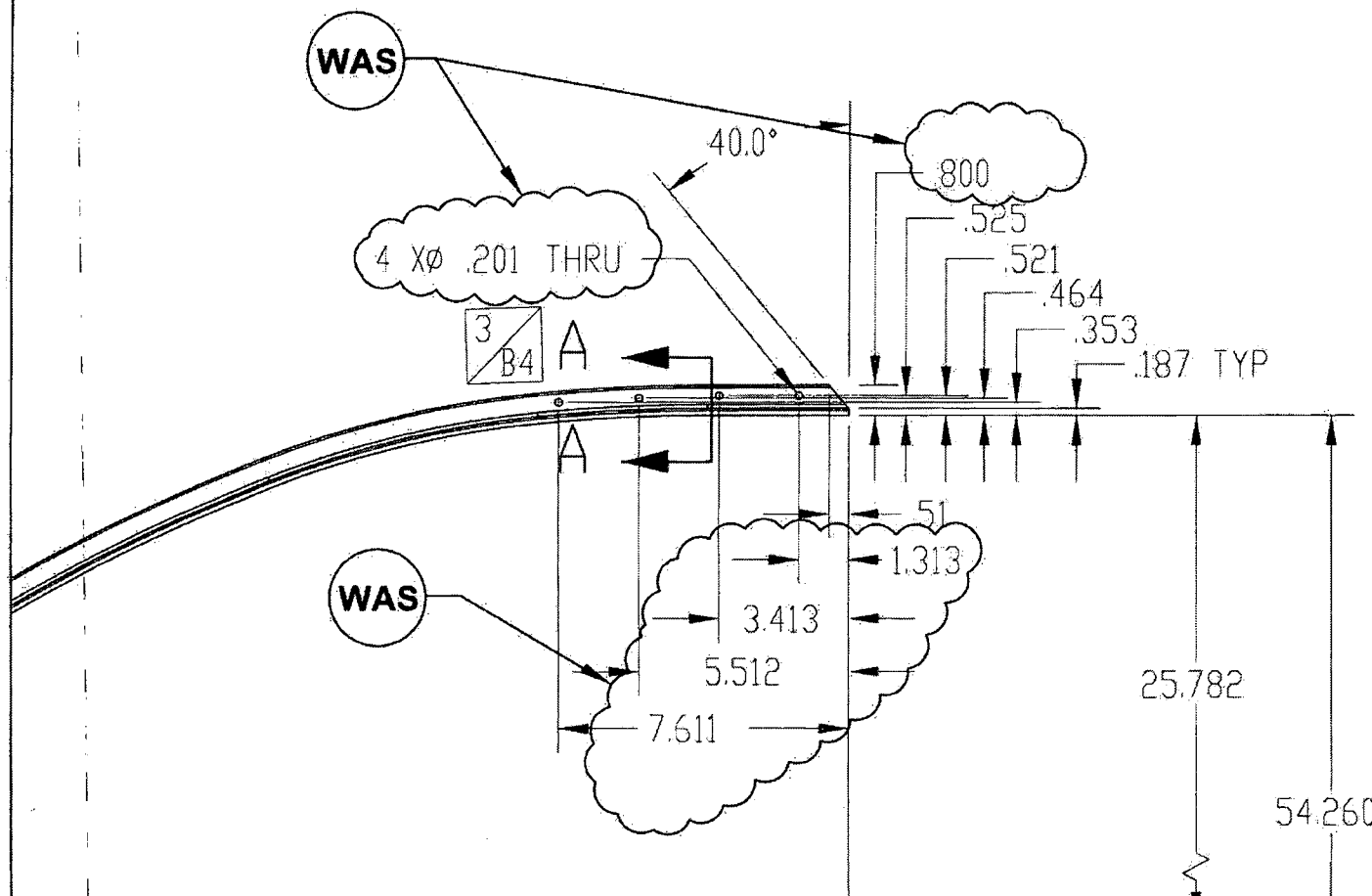
D-13-029

SHEET 1, ZONE A5-A6 & B5-B6 WAS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 119491 MLS

14-05-22

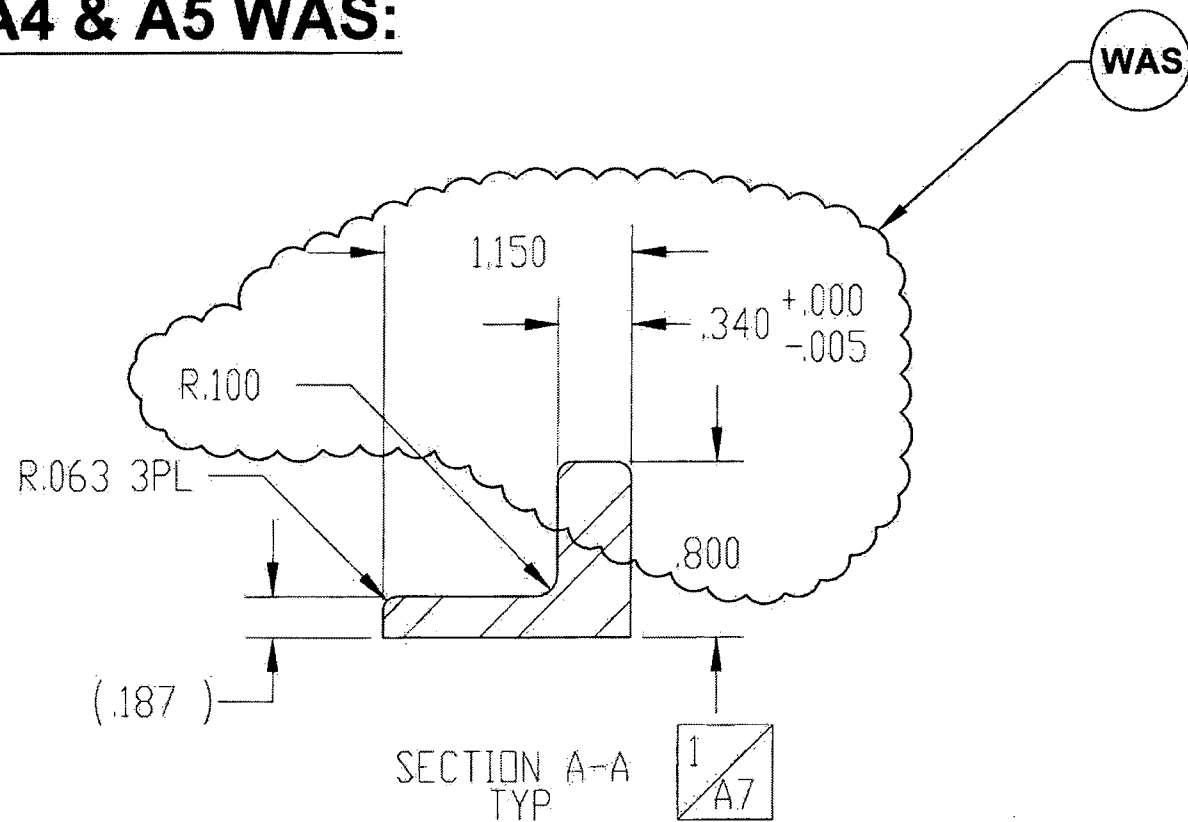


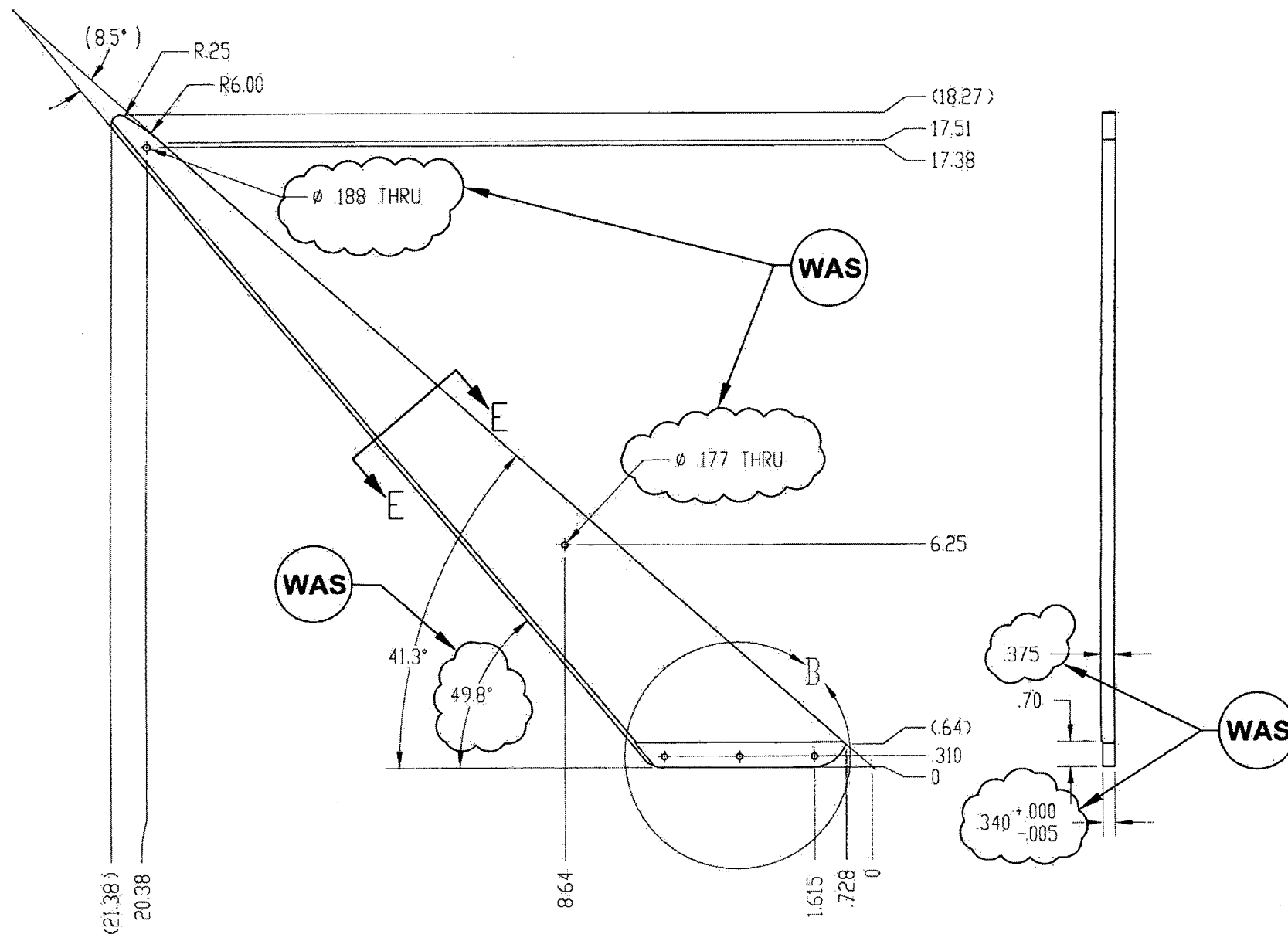
DOCUMENTS EFFECTED:

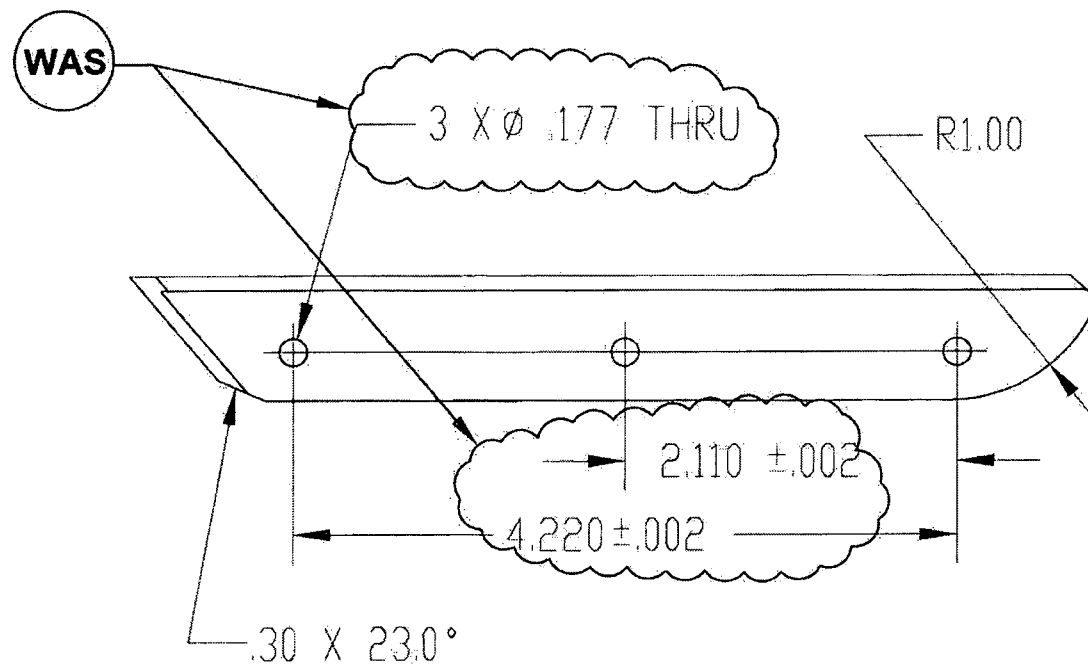
☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

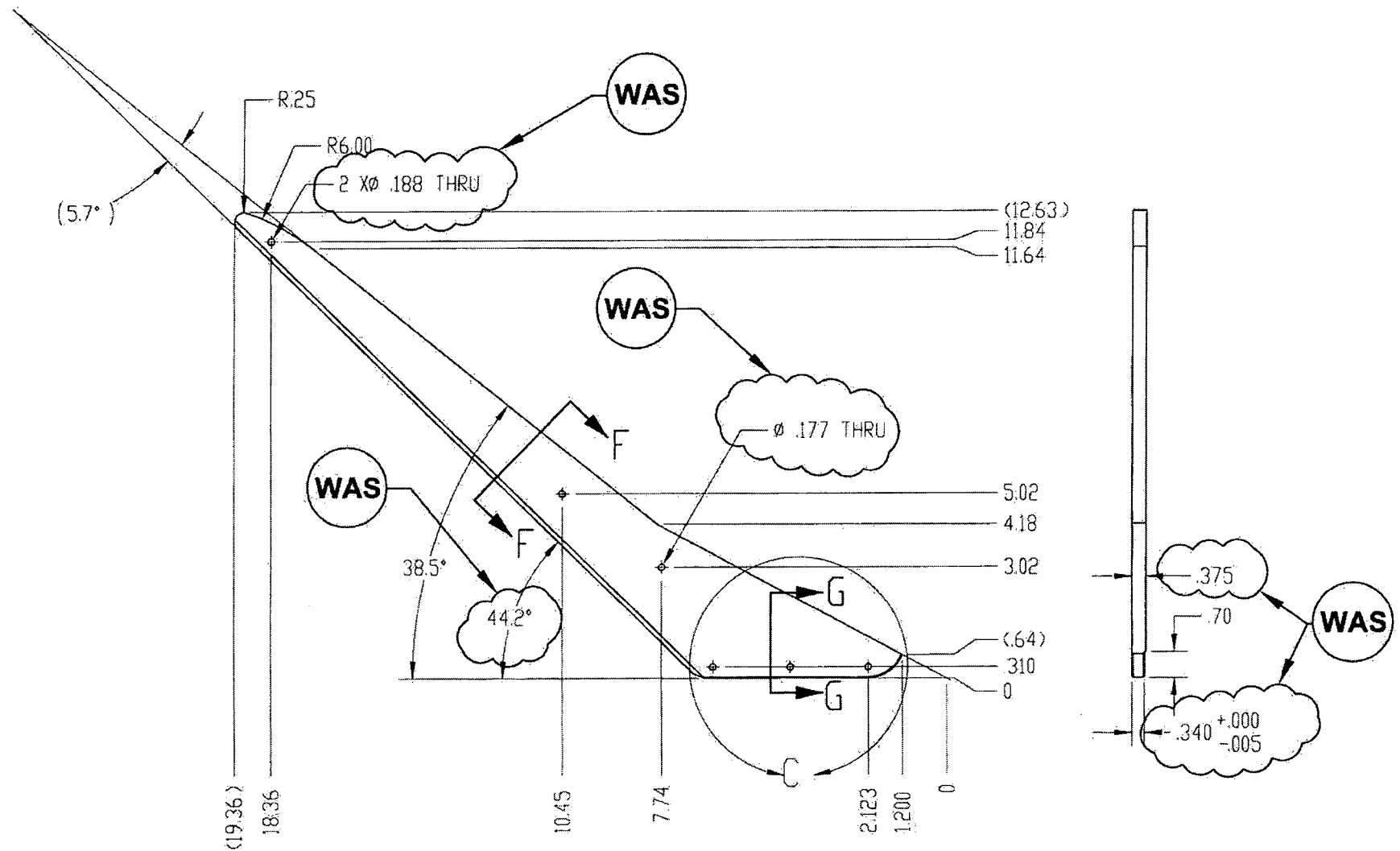
DER REVIEW REQUIRED
☐ YES ☒ NO

SHEET 3, ZONE A4 & A5 WAS:

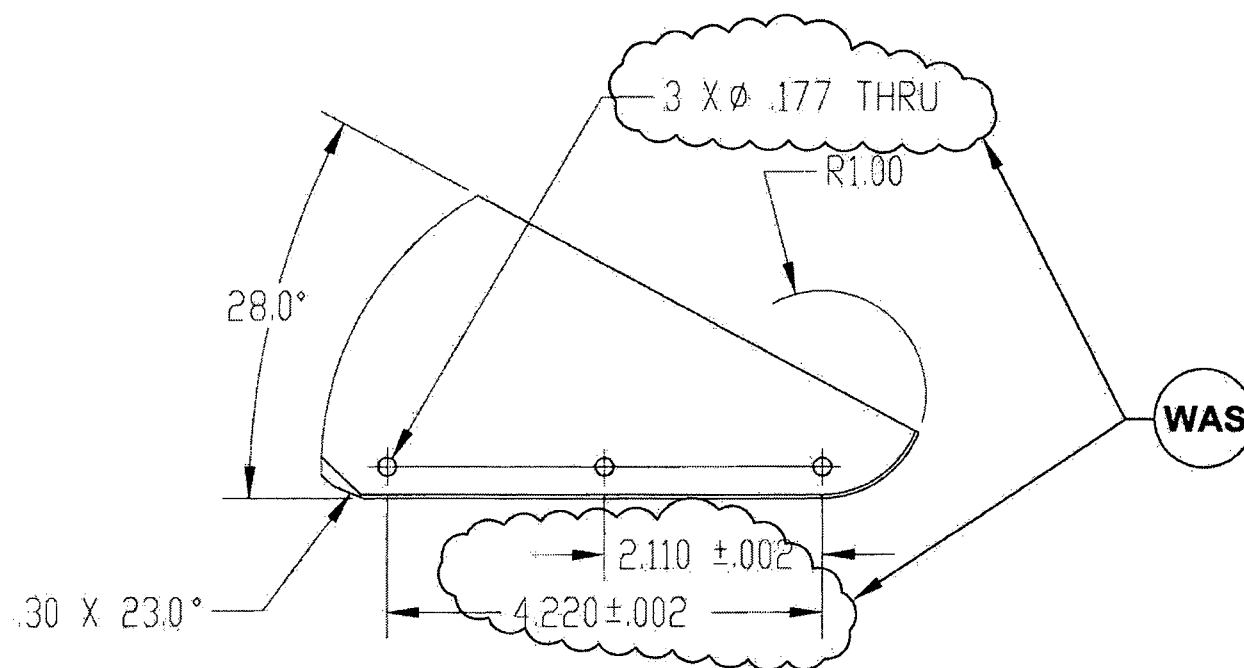
SHEET 4, WAS:

SHEET 4, ZONE C7 & C8 WAS:

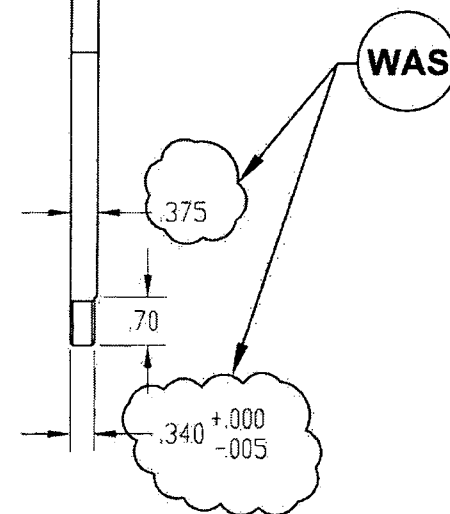
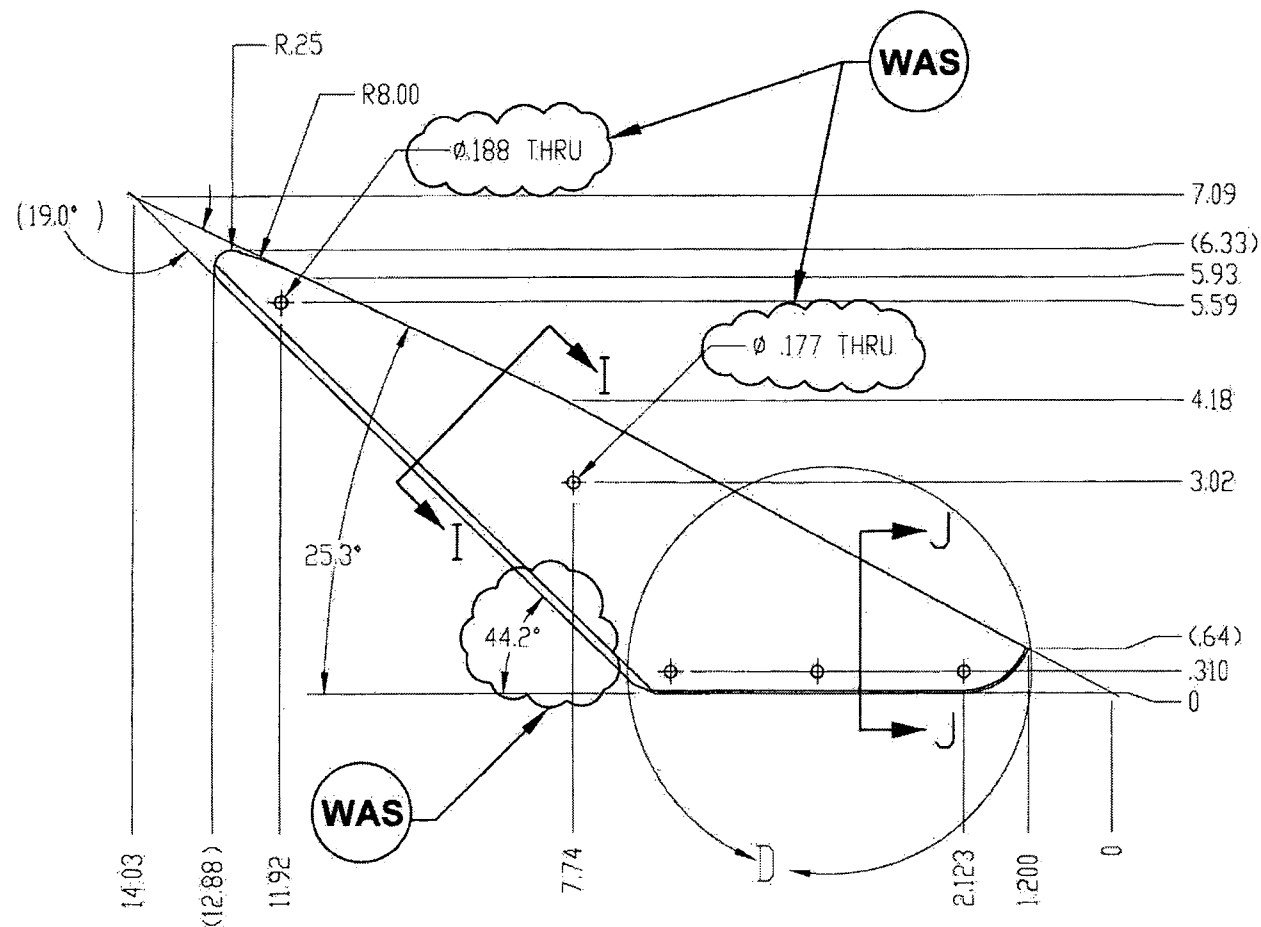
SHEET 5, WAS:

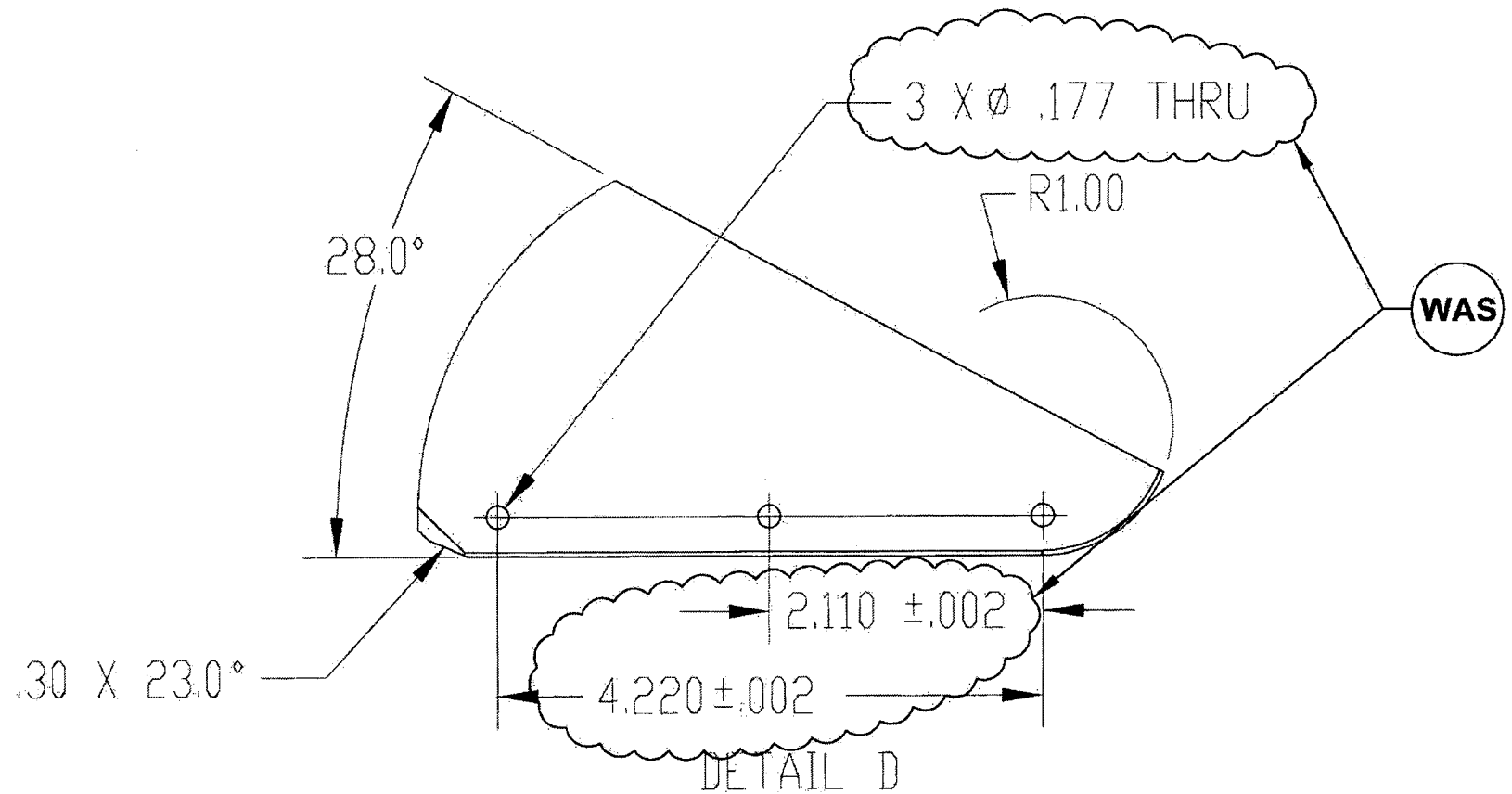


SHEET 5, ZONE C8, D7, & D8 WAS:



DETAIL C

SHEET 6, WAS:

SHEET 6, ZONE C6 & D6 WAS:

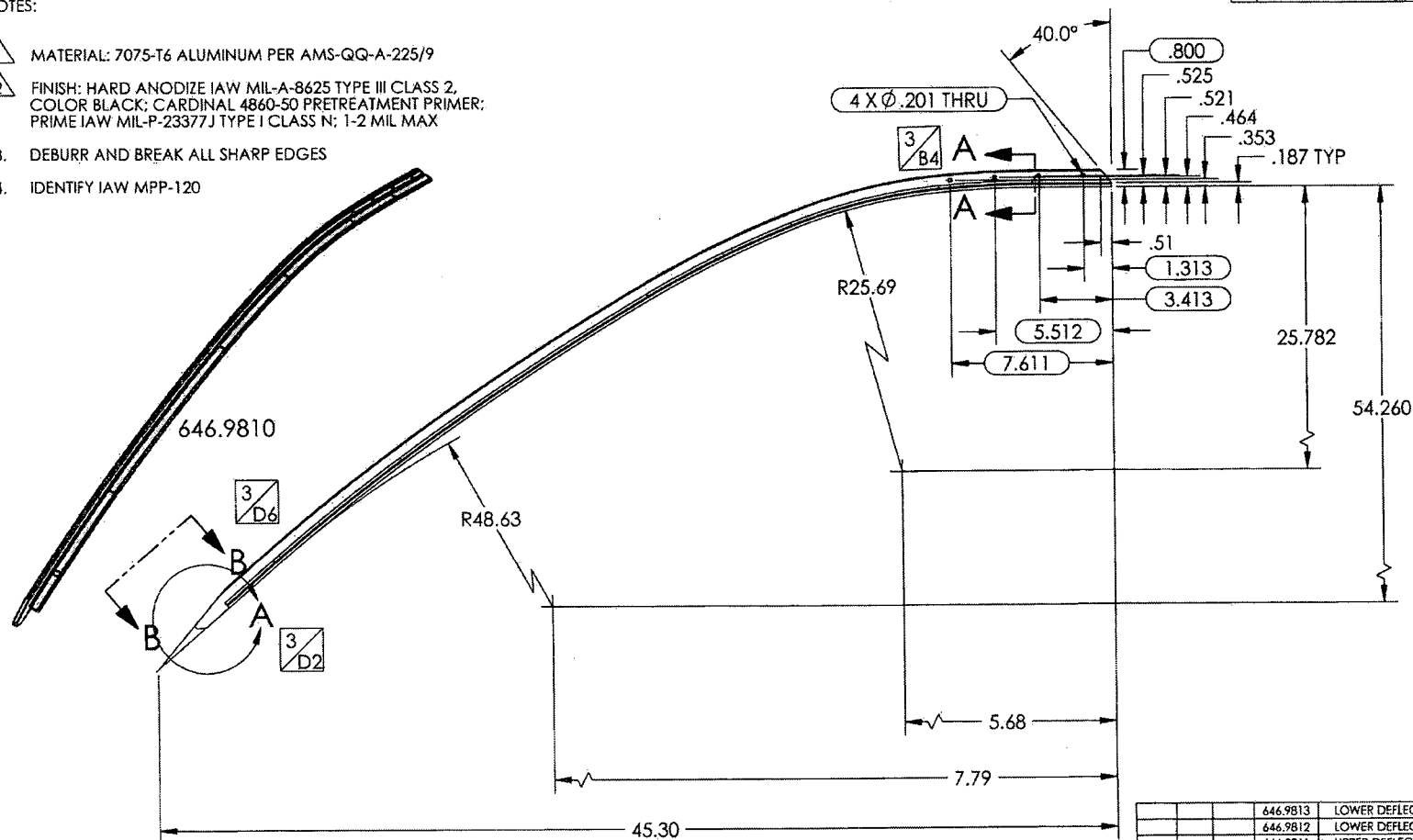
1 2 3 4 5 6 7 8

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NOTES:

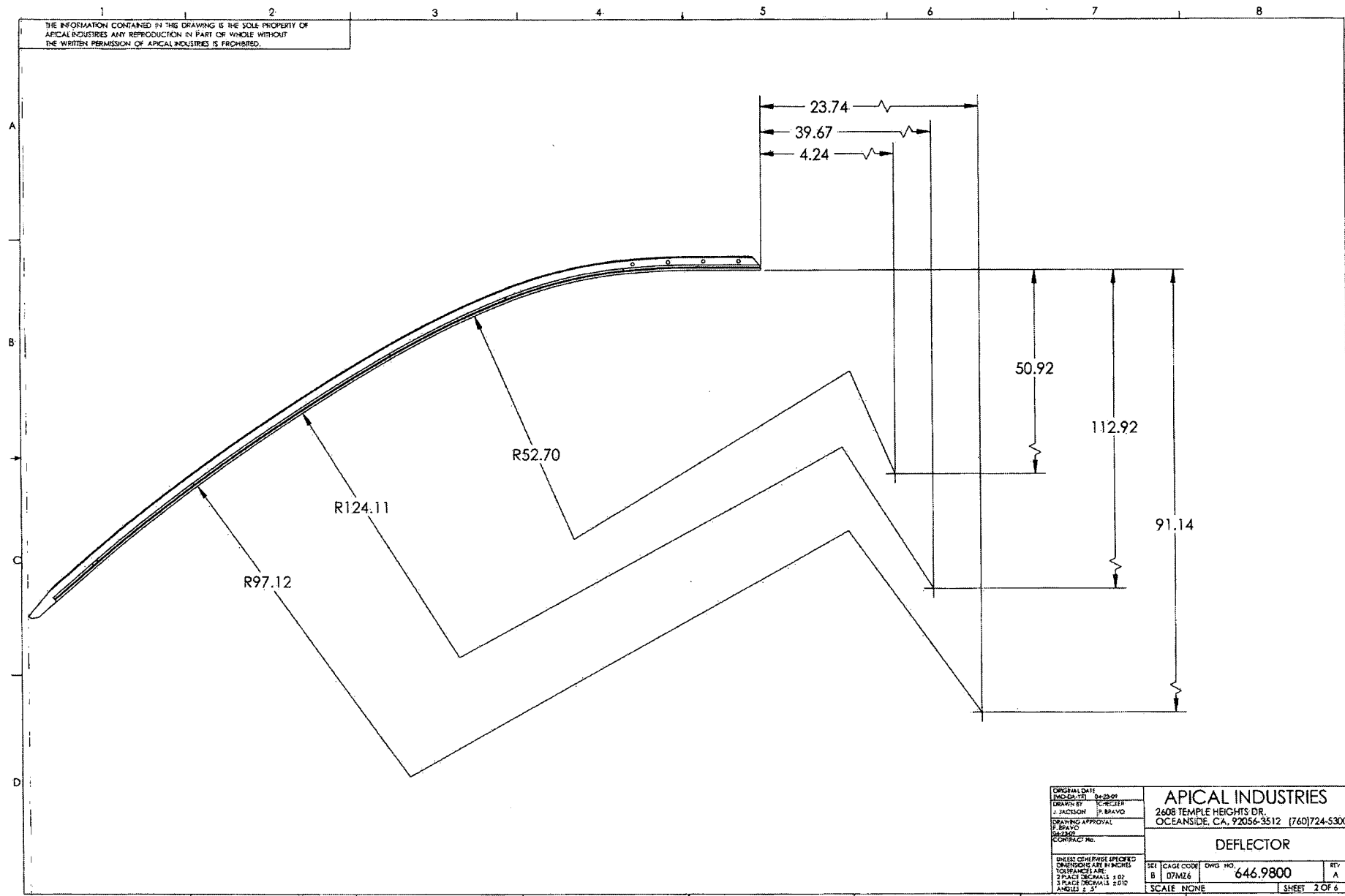
- 1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-225/9
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 DEBURR AND BREAK ALL SHARP EDGES
- 4 IDENTIFY IAW MPP-120

REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL PREPARE	04/22/09	F. BRANG
A	INCORPORATED ECH 03878	03/17/13	F. BRANG



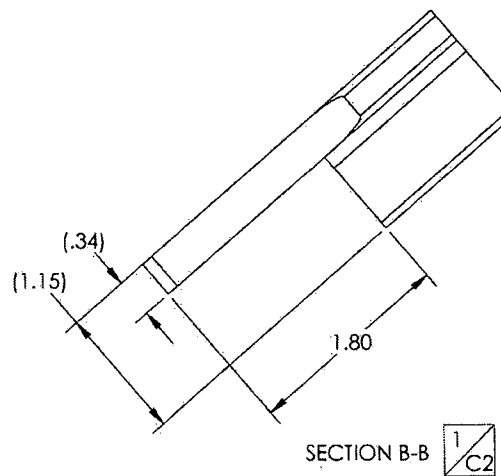
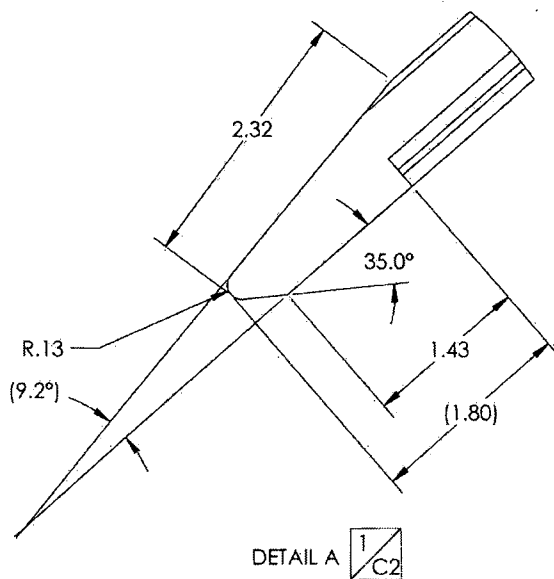
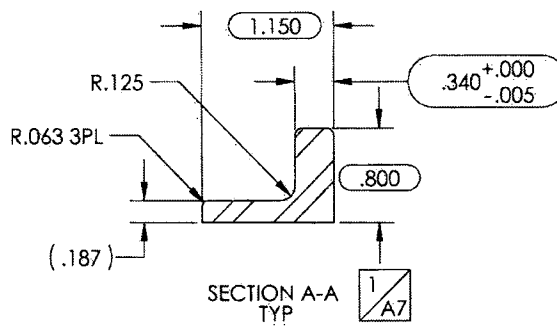
		646.9813	LOWER DEFLECTOR LOW	△	△
		646.9812	LOWER DEFLECTOR HIGH	△	△
		646.9811	UPPER DEFLECTOR	△	△
		646.9810	DEFLECTOR	△	△
	FIND #	PART NO.	DESCRIPTION	MATL	SPEC
QTY			PARTS LIST		
NEXT ASSY (S)			ORIGINAL DATE 04-23-09		
646.9500			DRAWN BY J. JACKSON		
			CHECKED F. BRANG		
			DRAWING APPROVAL P. BRANG		
			CONTRACT NO.		
			UNLESS OTHERWISE SPECIFIED		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES ARE:		
			2 PLACE DECIMALS ±.02		
			3 PLACE DECIMALS ±.010		
			ANGLES ±.5°		
SIZE	CAGE CODE	DWG. NO.	REV.		
B	07MA26	646.9800	A		
SCALE NONE			SHEET 1 OF 6		

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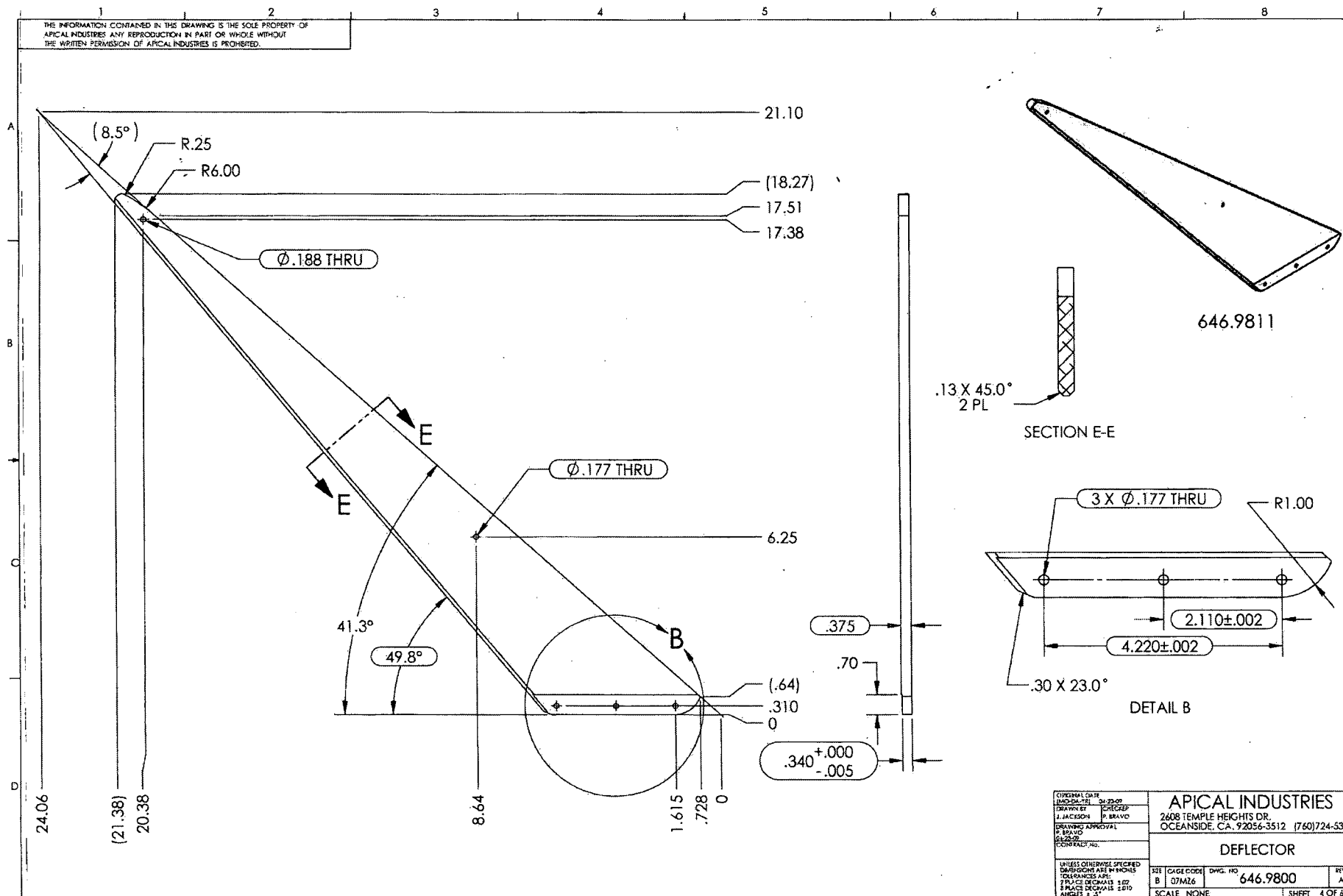
ORIGINAL DATE 04-20-01		APICAL INDUSTRIES	
DRAWN BY C. CREER		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. JACKSON		OCEANSIDE, CA, 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO		DEFLECTOR	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .02 3 PLACE DECIMALS ± .010 ANGLES ± .5°		SET B	REV A
		CAGE CODE 07M26	DWG. NO. 646.9800
		SCALE NONE	
		SHEET 2 OF 6	

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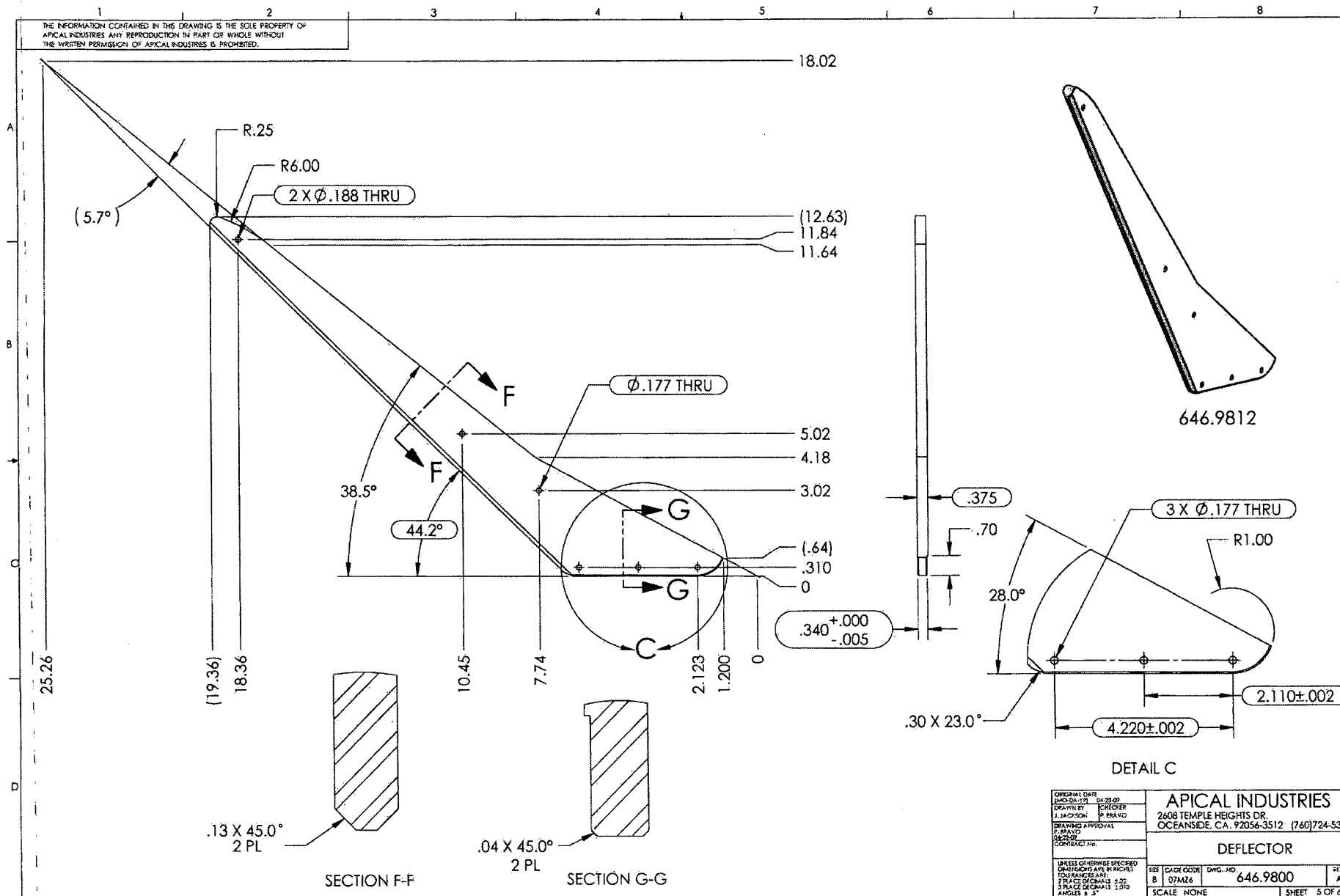


ORIGINAL DATE (ENCL. 1) 04-23-01		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY: C. HEDRUP J. JACOBSON P. BRAYO		DEFLECTOR	
DRAWING APPROVAL P. BRAYO		SEE CAGE CODES B 071426	
COOPERATING NO.		DWG. NO. 646.9800	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SCALE: NONE	
		SHEET 3 OF 6	

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19.00

R.25

R8.00

$\phi .188$ THRU

7.09

4.18

14.03

11.92

25.3°

44.2°

$\phi .177$ THRU

2.123

1.200

0

7.74

3.02

(.64)

.310

0

.375

.70

$.340^{+.000}_{-.005}$

646.9813

3 X $\phi .177$ THRU

R1.00

28.0°

.30 X 23.0°

2.110 ± .002

4.220 ± .002

DETAIL D

SECTION I-I

.13 X 45.0°
2 PL

SECTION J-J

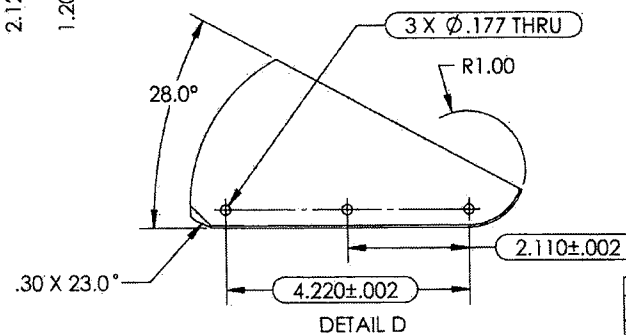
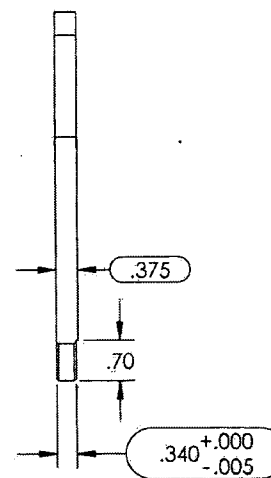
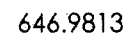
.04 X 45.0°
2 PL

ORIGINAL DATE: 04-21-00
DRAWN BY: J. JACKSON
CHECKED BY: P. BRAVO
DRAWING APPROVAL: P. BRAVO
CONTRACT NO.:
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACES DECIMALS ± .01
3 PLACES DECIMALS ± .005
ANGLES ± 1°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5311

DEFLECTOR

REV. 8
CAGE CODE: 07WZ6
DWG. NO. 646.9800
SCALE: NONE
SHEET 6 OF 6



ORIGINAL DATE (MM/DD/YYYY) 04/27/00 DRAWN BY J. L. JACKSON P. BRAVO DRAWING APPROVAL P. BRAVO 04/27/00 CONTRACT NO.	APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300		
DEFLECTOR			
UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. HOLE DIMENSIONS ± .010 2. HOLE DEPT. ± .010 3. HOLE DRILLING ± .010 4. HOLE DRILLING ± .010			
SEE B	CAGE CODE 07M126	DWG. NO. 646.9800	REV. A
SCALE NONE			SHEET 6 OF 6



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63109

Date: 20-Jun-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity		Description	
1 lot	Part: ASST Rev:		
12 PCS 646.9710 (14.50) 5 PCS 649.8310 (14.50) 6 PCS 646.9811 (32.60) 4 PCS 647.9412 (31.60) 4 PCS 649.5312 (10.70) 4 PCS 649.5310 (11.45)			
HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PRICE IS PER PIECE Job: 20140381 PO: 24541 Line:			
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: <u>20/6/14</u> CERTIFIED SIGNATURE: <u></u> RECEIVER SIGNATURE: _____			